

Work Order ID 78324

January-05-12 9:05:03 AM

78324

Page 1

Item ID: D2432 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: 206 (24") Bearpaw
 Start Date: 1/05/12 Start Qty: 16.00 ***16*** Cust Item ID:
 Required Date: 1/13/12 Req'd Qty: 16.00 ***16*** Customer:
 Reference:

Approvals: Process Plan: W Date: Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2432	Rev F3								

120 0.00
120 FLOW WATER JET
 Waterjet Memo 0.00
 FLOW CNC Waterjet Cut Blank as per D2432 File

B12-1-6

(16)

130 0.00
130 HAAS CNC VERTICAL MACHINING #1
 HAAS I Memo 0.00
 HAAS CNC vertical machine #1 1-Inspect material for defects or damage prior to machining
 2-Machine as per Folio and Dwg D2432 Identify as D2432F
 3-Deburr

FK 2/01/17

B12-1-6

140 0.00
140 QC2- Inspect parts off machine FAI/FAIB
 QC Memo 0.00
 Quality Control

FK 12/01/17

16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC8- Inspect parts - second check	0.00							
150									
QC	Memo	0.00							
Quality Control									
151	Identify as per dwg & Stock Location: _____	0.00							
151									
Packaging	Memo	0.00							
Packaging									
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.00							
Quality Control									

Handwritten notes:
 12/01/19
 12-01-19
 (14)

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Picklist Print

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Page 1

Work Order ID: 78324
 Parent Item: D2432
 Parent Item Name: 206 (24") Bearpaw

Start Date: 1/05/12
 Start Qty: 16.00
 Required Date: 1/13/12
 Required Qty: 16.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MUHMWB10 UHMW 1" Black		Purchased	No			120	sf	683.6443	3.7	59.2			

B12-1-6

Location	Loc Qty	Loc Code
MAT018	360	
120035	360	
MAT019	323.6443158	
117321	74.6	
117738	95.8	
117819	83.3	
118814	1.5	
119145	68.4443158	

120035

~~117738~~
120035

(16)

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DART AEROSPACE LTD		Work Order:	78324
Description: Bearpaw		Part Number:	D2432
Inspection Dwg: D2432 Rev: F3		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.063 x 45°	+0.030/-0.010	0.050 x 45°	✓		FK-04	Vern.
B	5.500	+/-0.030	5.500	✓		"	"
C	0.200	+/-0.030	0.190	✓		FK-06	Depth gauge
D	0.25 x 45°	+/-0.030	0.270	✓		FK-04	Vern.
E	R0.250	+/-0.030	0.250	✓		rad gauge	
F	0.250	+/-0.010	0.242	✓		FK-04	Vern.
G	0.625	+/-0.030	0.620	✓		"	"
H	0.375	+/-0.010	0.375	✓		"	"
I	0.950	+0.030/0.010	0.942	✓		"	"
J	19.000	+/-0.030	19.000	✓		FK-05	Tape.
K	3.14	+/-0.030	3.146	✓		FK-04	Vern
L	3.28	+/-0.030	3.286	✓		"	"
M	Ø0.260	+0.005/-0.000	0.260	✓		"	"
N	Ø0.93	+/-0.030	0.927	✓		"	"
O	0.30	+0.030/-0.000	0.319	✓		FK-06	Depth gauge
P	23.750	+/-0.030	23.75	✓		FK-05	Tape.
Q	7.375	+/-0.030	7.375	✓		CNC-02 3.000	Vern.
R	4.250	+/-0.010	4.250	✓		FK-04	Vern.
S	2.000	+/-0.030	2.000	✓		"	"
T	9.000	+/-0.010	9.000	✓		CNC-02	Vern
U	9.000	+/-0.010	9.000	✓		"	Vern.
V	0.375	+/-0.010	0.380	✓		FK-04	Vern.

Measured by: FK.	Audited by: <i>OK</i>	Prototype Approval:	N/A
Date: 12/01/17	Date: 12/01/19	Date:	

Rev	Date	Change	Revised by	Approved
A	04.01.09	New Issue. P/O K10008/D206-559-015	KJ/RF	<i>[Signature]</i>

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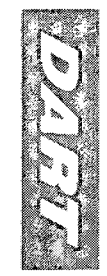
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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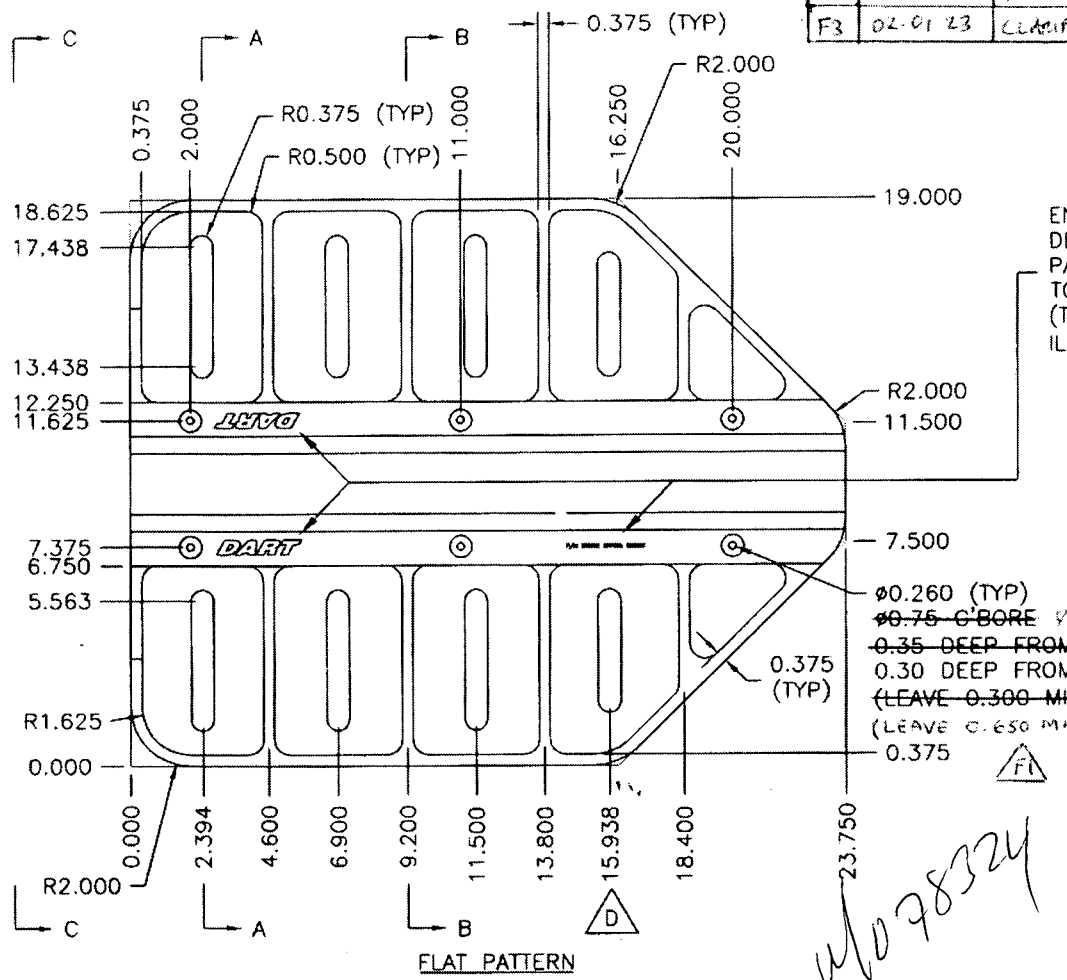
F1	99.03.03	ADD DEC 9143
F2	01.03.28	Ø0.73 WAS Ø0.75 RF
F3	02.01.23	CLARIFY CORE DIMS RF

RELEASED
98.06.17 KE



ENGRAVE LOGO TO MAX DEPTH OF 0.012. ENGRAVE PART AND BATCH NUMBERS TO MAX DEPTH OF 0.010. (TYPICAL LOCATION AS ILLUSTRATED)

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. F
KE	KE		
CHECKED	APPROVED	DRAWING NO.	SHEET 1 OF 2
MM	MM	D2432	
DATE	TITLE	SCALE	
98.05.12	BEARPAW	1:6	
A	95.10.31	NEW ISSUE	
B	96.01.24	RE-DESIGN	
C	96.03.26	CHANGE BORE AND C'BORE DEPTH	
D	96.06.04	MOVE SLOT	
E	97.02.27	CHANGE C'BORE DEPTH, BORE RADIUS	
F	98.05.12	CHANGE C'BORE, ADD B AND F P/N	



EFFECTIVE	DEOS
9143	

D2432F: FLAT BEARPAW
D2432B: BENT BEARPAW

MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689
1.00 THICK (MACHINE TO 0.950)

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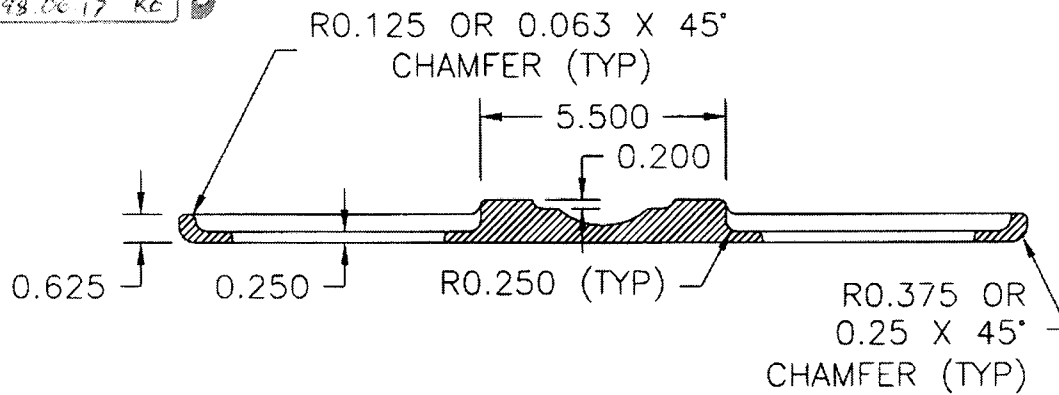
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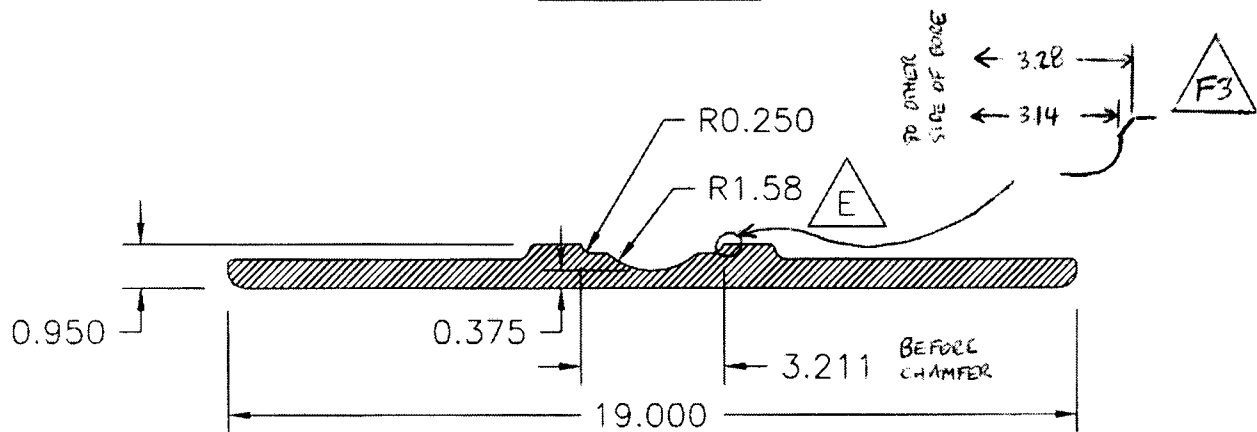


DESIGN KE	DRAWN BY KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2432	REV. F SHEET 2 OF 2
DATE 98.05.12		TITLE BEARPAW	SCALE 1:4

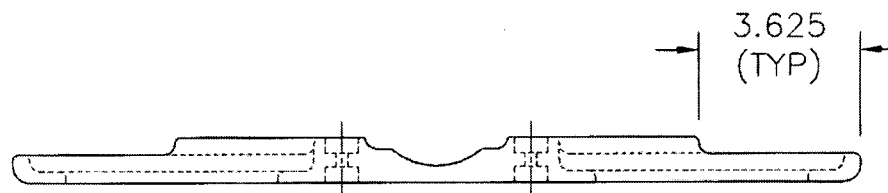
RELEASED
98.06.17 KE



SECTION A-A



SECTION B-B



SECTION C-C

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